

Date: Monday, 11/19/2007 3:49:30 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 35897	
Estimate Number : 10611	
P.O. Number : N/A	Part Number : D265611
This Issue : 11/19/2007 S.O. No. : N/A	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : D
Previous Run : 32818	Material : N/A
	Due Date : 11/30/2007
Written By : <u>JD</u>	Qty: 12 Um: Each
Checked & Approved By : <u>JD 07.11.19</u>	
Comment : Est: D 02.10.24 Re-format KJ est rev E 07.06.06 waterjet EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



$XB1 = 9.35$



Comment: Qty.: 0.8500 sf(s)/Unit Total : 10.2000 sf(s)  $12.75$   
1010/1025/A21/6aA SHEET  $106069$   $1B 07-12-S$   $104181 \times 2 1.7$   
 $104221 \times 2 1.7$

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D2656  
Dwg Rev: D  
Prog Rev: D

$1B 07-12-S$

15

2-Deburr if necessary  $1B 07-12-S$

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



$1B 07-12-S$



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

$5$   $11/26/05$  15

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326  
2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-11

$80$   $07/12/11$   
 $8B$   $07/12/12$

15  
15

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: PD Date: 07/12/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 3:49:30 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35897

Part Number: D265611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

07/12/12

(X15)

7.0

POWDER COATING

POWDER COATING



M105642



(15X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h

07/12/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-13

(X15)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F-14

HL

07-12-13

(X15)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

2007/12/13

Job Completion



min 2007/12/13

U

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35897
Description: Wearshoe		Part Number:	D2656-11
Inspection Dwg: D2656 Rev: D		Page 1 of 1	

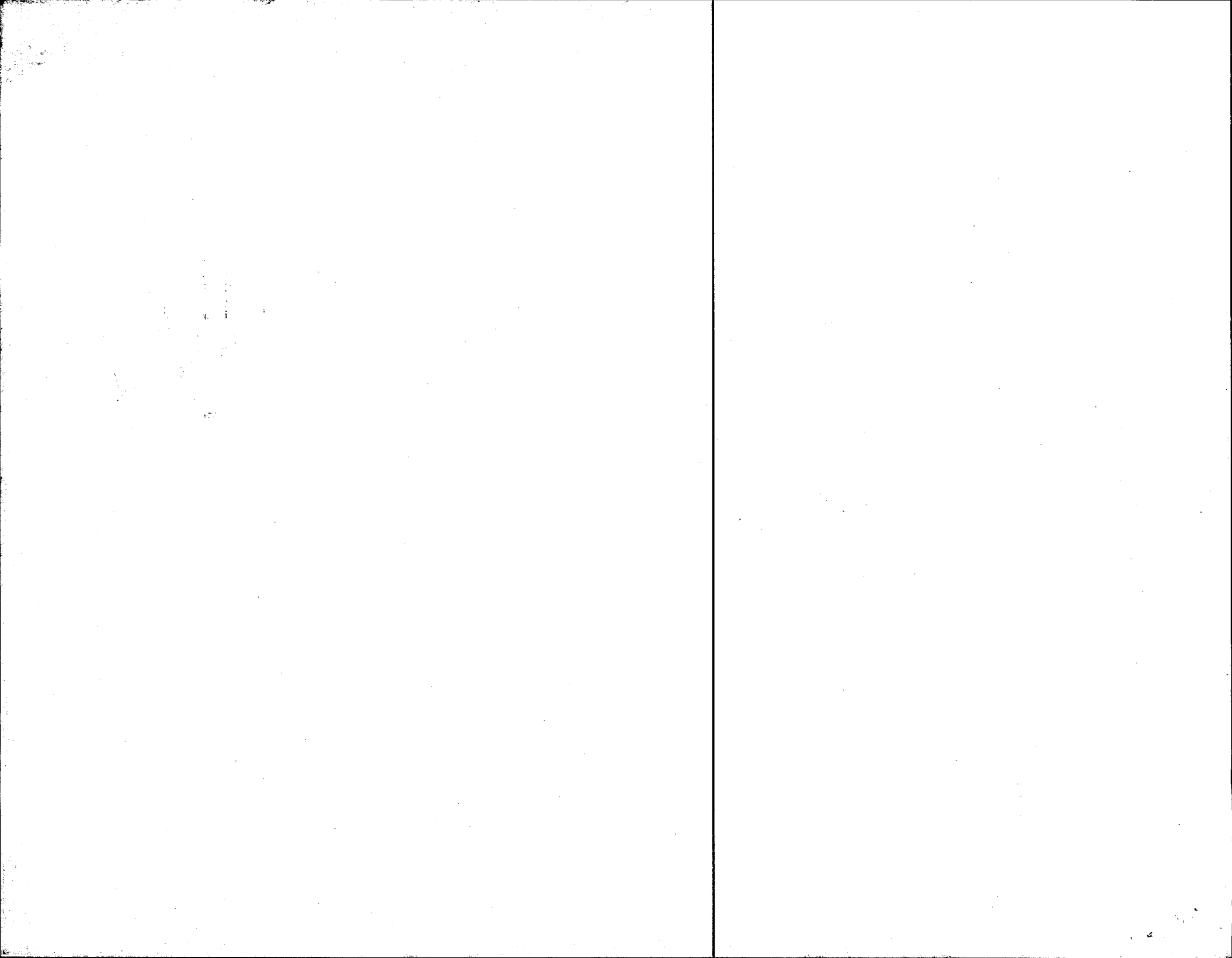
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.650	+/-0.010	26.650	✓			
23.150	+/-0.010	23.150	✓			
21.150	+/-0.010	21.150	✓			
17.650	+/-0.010	17.650	✓			
13.400	+/-0.010	13.400	✓			
9.150	+/-0.010	9.150	✓			
5.650	+/-0.010	5.650	✓			
2.000	+/-0.010	2.000	✓			
1.885	+/-0.010	1.886	✓			
0.300	+/-0.010	0.306	✓			
0.300	+/-0.010	0.305	✓			

Measured by: JB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07-12-5	Date: 11/2/05	Date:	N/A

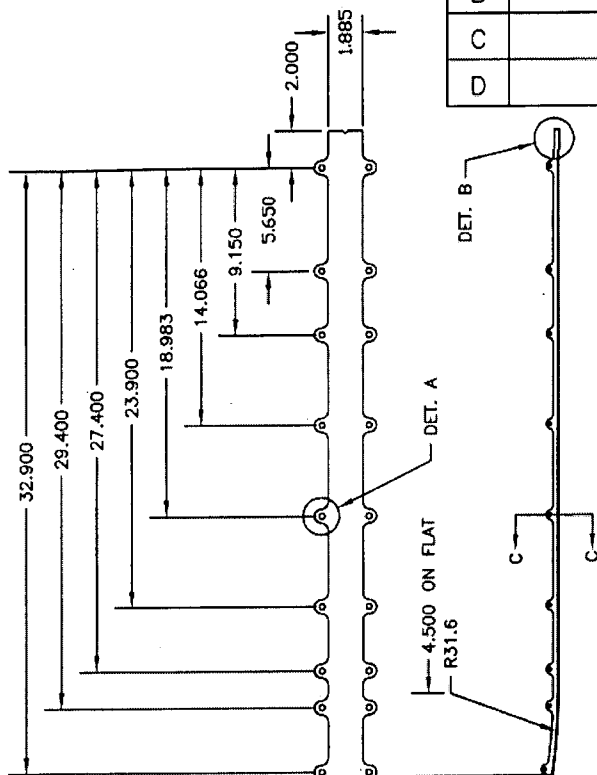
Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM [Signature]	[Signature]



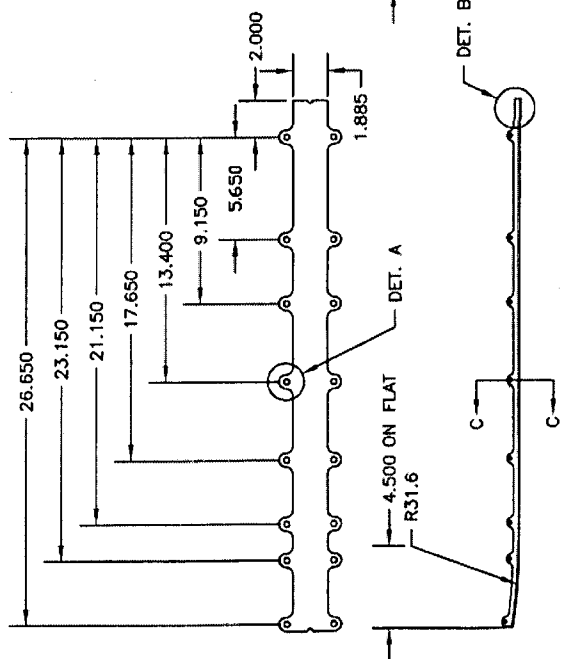


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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

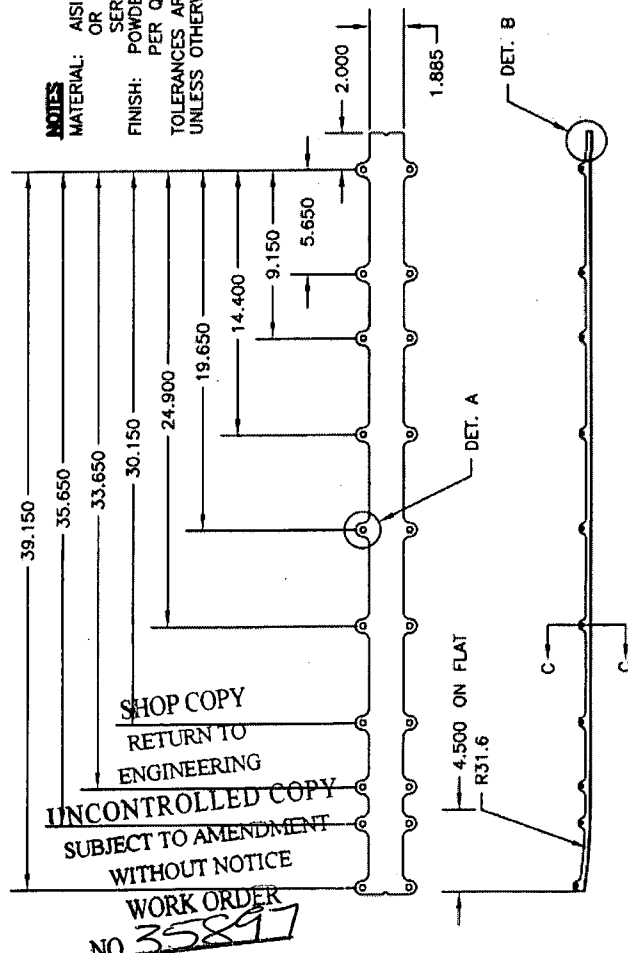
D2656-13



D2656-11



D2656-15



**NOTES**  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
 PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED

RELEASED  
 05-09-08

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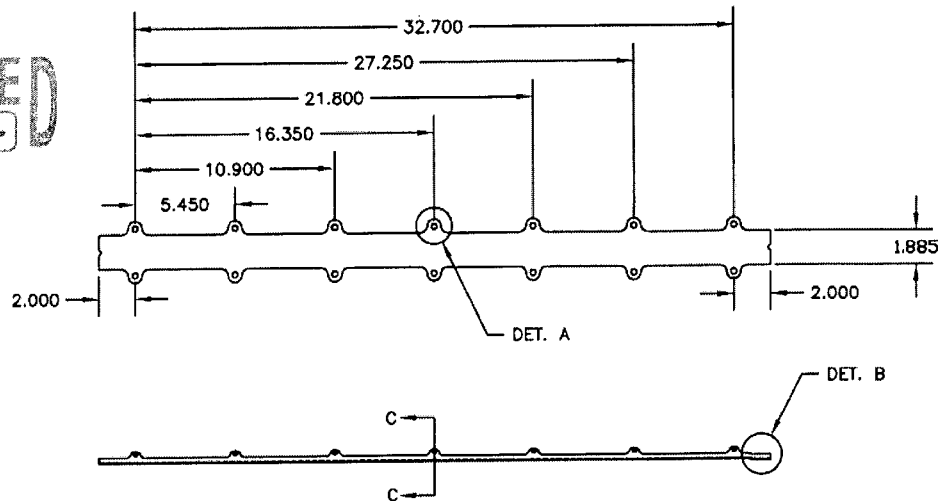
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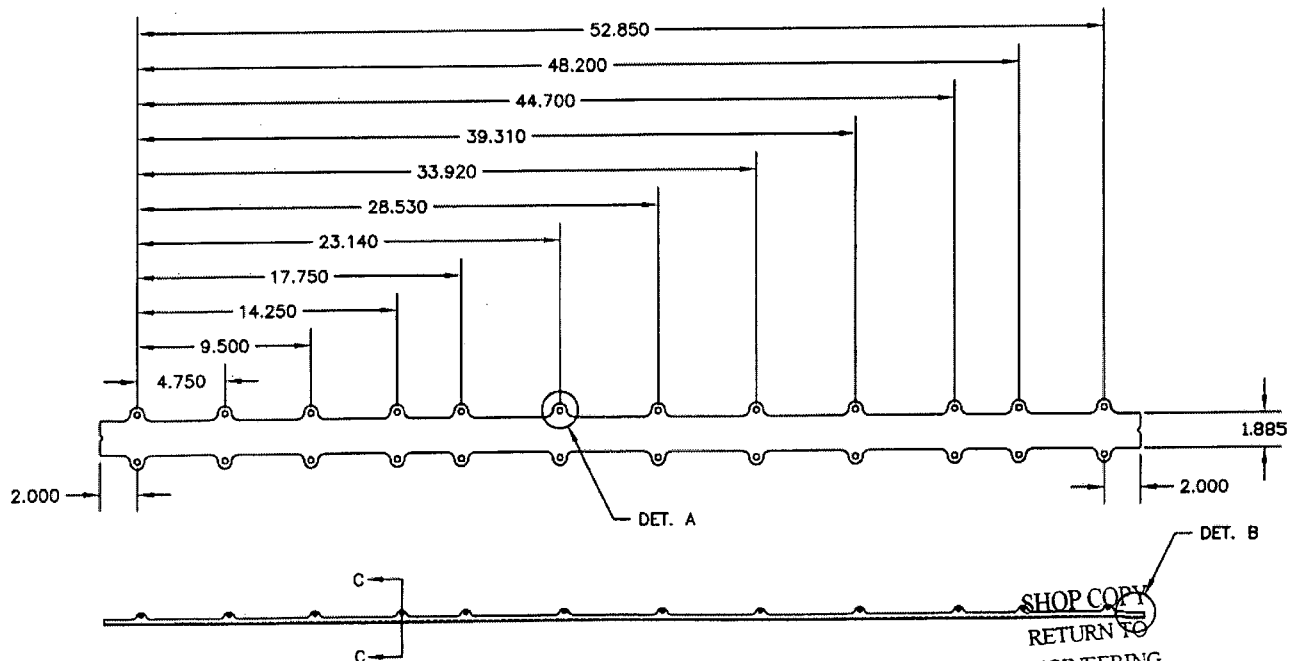
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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05.09.06 *[Signature]*

### D2656-21



### D2656-23



#### NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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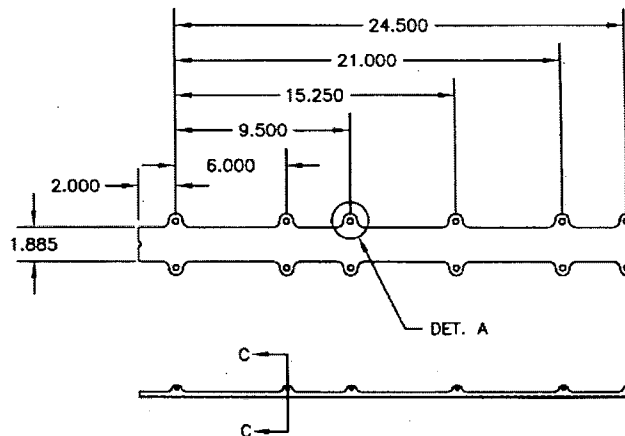
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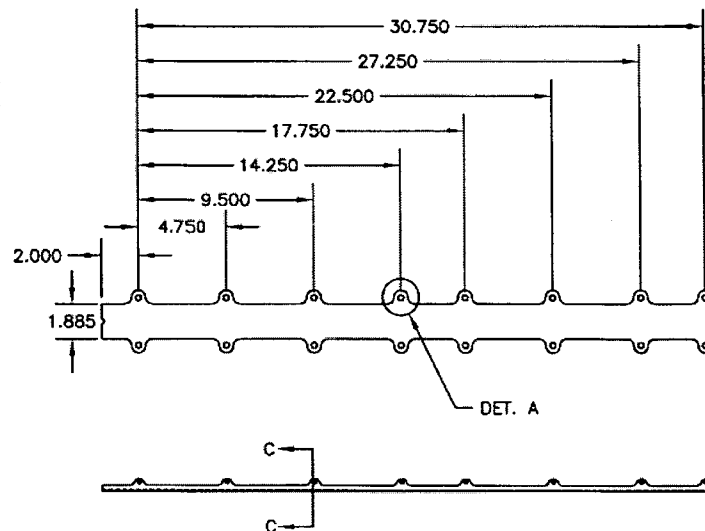


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		TITLE	WEARSHOE	SHEET 3 OF 4
				SCALE 1:10

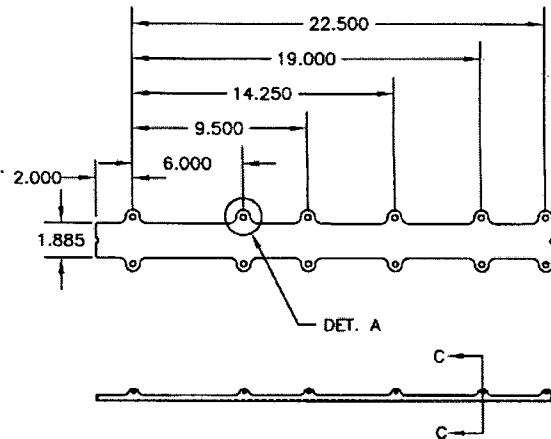
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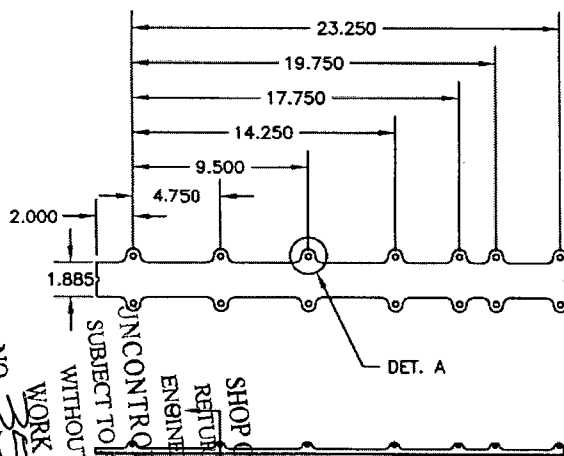
**D2656-37**



**D2656-31**



**D2656-35**



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05.07.06

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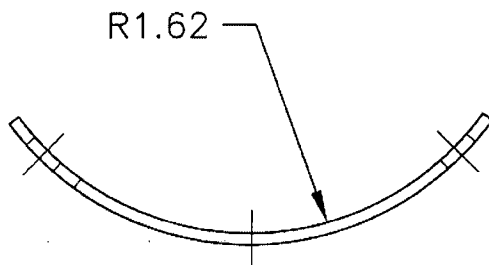
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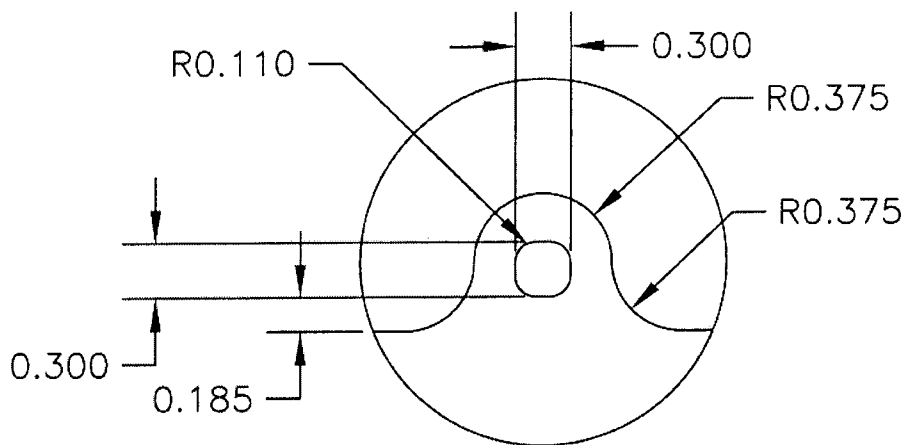
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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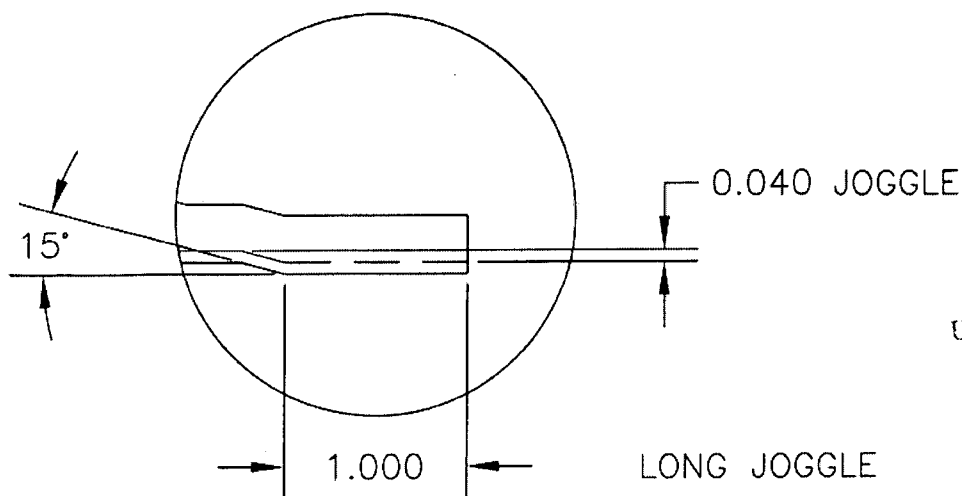


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### DETAIL A



### DETAIL B



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